

# Work Order ID 91423

October-10-12 9:06:23 AM

**\*91423\***

Page 1

Item ID: D4541-5

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Bracket

Stop

**\*NS2\***

Start Date: 10/10/2012 Start Qty: 15.00

**\*15\***

Cust Item ID:

Required Date: 10/12/2012 Req'd Qty: 15.00

**\*15\***

Customer:

Reference:

Approvals:

Process Plan: ML5

Date: 12-10-10

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4541

C

100

0.00

**\*100\***

Waterjet

Memo

0.00

FLOW CNC Waterjet

1- Cut as per dwg

Prog rev: C

Dwg rev: C

2- Deburr

110

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*110\***

QC

Memo

0.00

Quality Control

(15)

B12-11-5

(15)

B12-11-8

# Work Order ID 91423

October-10-12 9:06:23 AM

**\*91423\***

Page 2

Item ID: D4541-5

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Bracket

Stop **\*NS2\***

Start Date: 10/10/2012 Start Qty: 15.00

**\*15\***

Cust Item ID:

Required Date: 10/12/2012 Req'd Qty: 15.00

**\*15\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00

**\*120\***

QC

Memo

0.00

Quality Control

DAS  
15  
9-89  
12/1/05

23  
count

125

0.00

**\*125\***

Small Fab

Memo

0.00

Small Fab

BEND TABS PER DWG

SB  
12/6/12

23

127

QC5- Inspect part completeness to step on W/O

0.00

**\*127\***

QC

Memo

0.00

Quality Control

DAS  
15  
9-89  
12/1/19

23

Alschnee

DC

23 12/1/19

DAS  
15  
9-89  
12/1/19

23  
count

# Work Order ID 91423

October-10-12 9:06:23 AM

**\*91423\***

Page 3

Item ID: D4541-5

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Bracket

Stop **\*NS2\***

Start Date: 10/10/2012 Start Qty: 15.00

**\*15\***

Cust Item ID:

Required Date: 10/12/2012 Req'd Qty: 15.00

**\*15\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

Identify as per dwg & Stock Location: *ST163*

0.00

**\*150\***

Packaging

Memo

0.00

Packaging

*23*

*12/11/21 JB*

160

QC21- Final Inspection - Work Order Release

0.00

**\*160\***

QC

Memo

0.00

Quality Control

*12/11/22*

*MF 12-11-21*

# Picklist Print

October-10-12 9:06:26 AM

Page 1

Work Order ID: 91423

\*91423\*

Parent Item: D4541-5

\*D4541-5\*

Parent Item Name: Bracket

Start Date: 10/10/2012

Required Date: 10/12/2012

Start Qty: 15.00

Required Qty: 15.00

Comments: IPP revA 12.01.04 New Issue EC verified by:DD IPP REV:B  
12.02.24 as per dwg revb DD verf:EC IPP REV:C 12.05.08 as  
per dwg revC DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.032		Purchased		No		100	sf	700.0600	0.204	3.221053			

\*M6061T6S 032\*

6061-T6 Sheet 0.032"

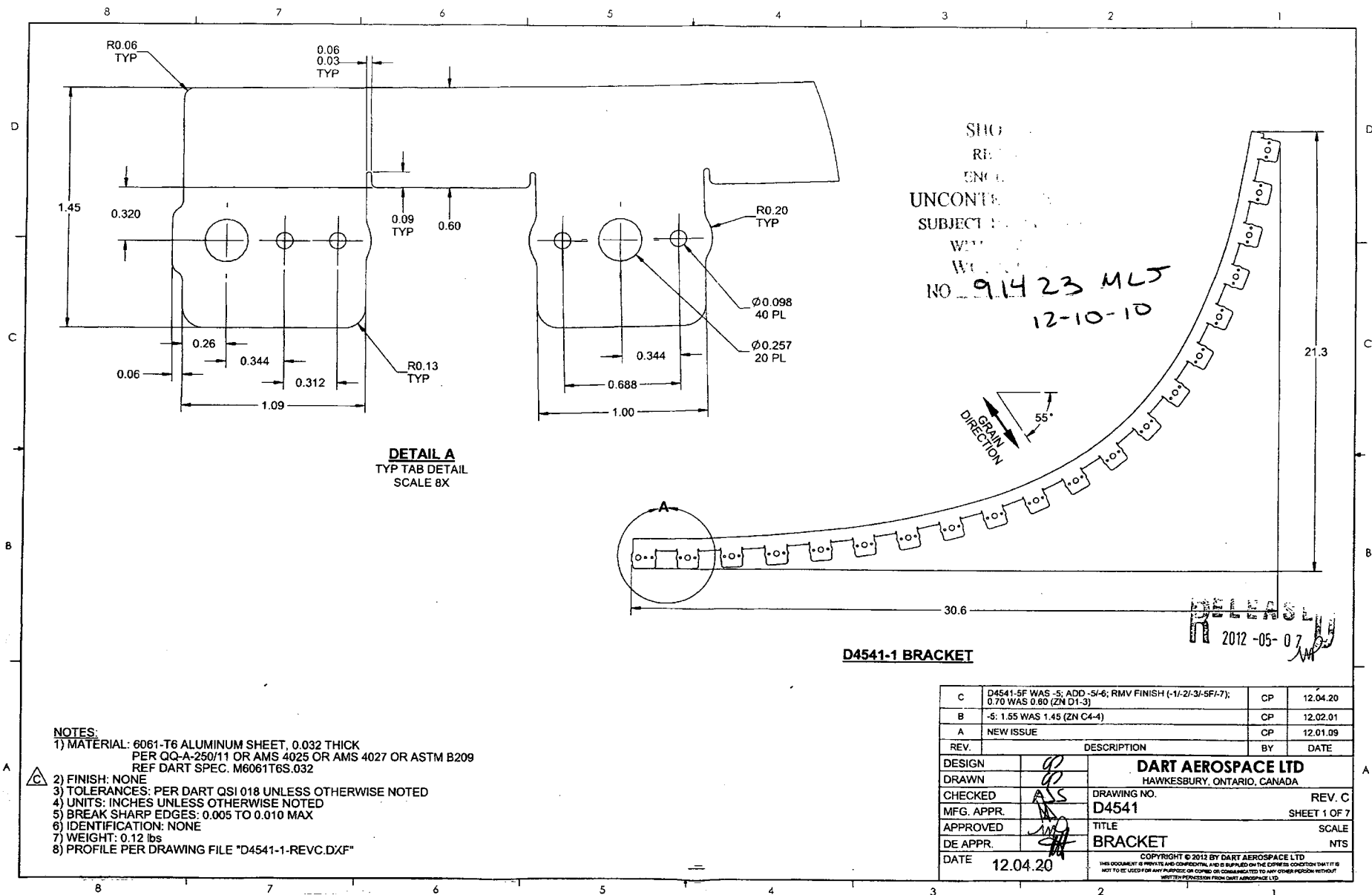
\*\*

B12-11-5

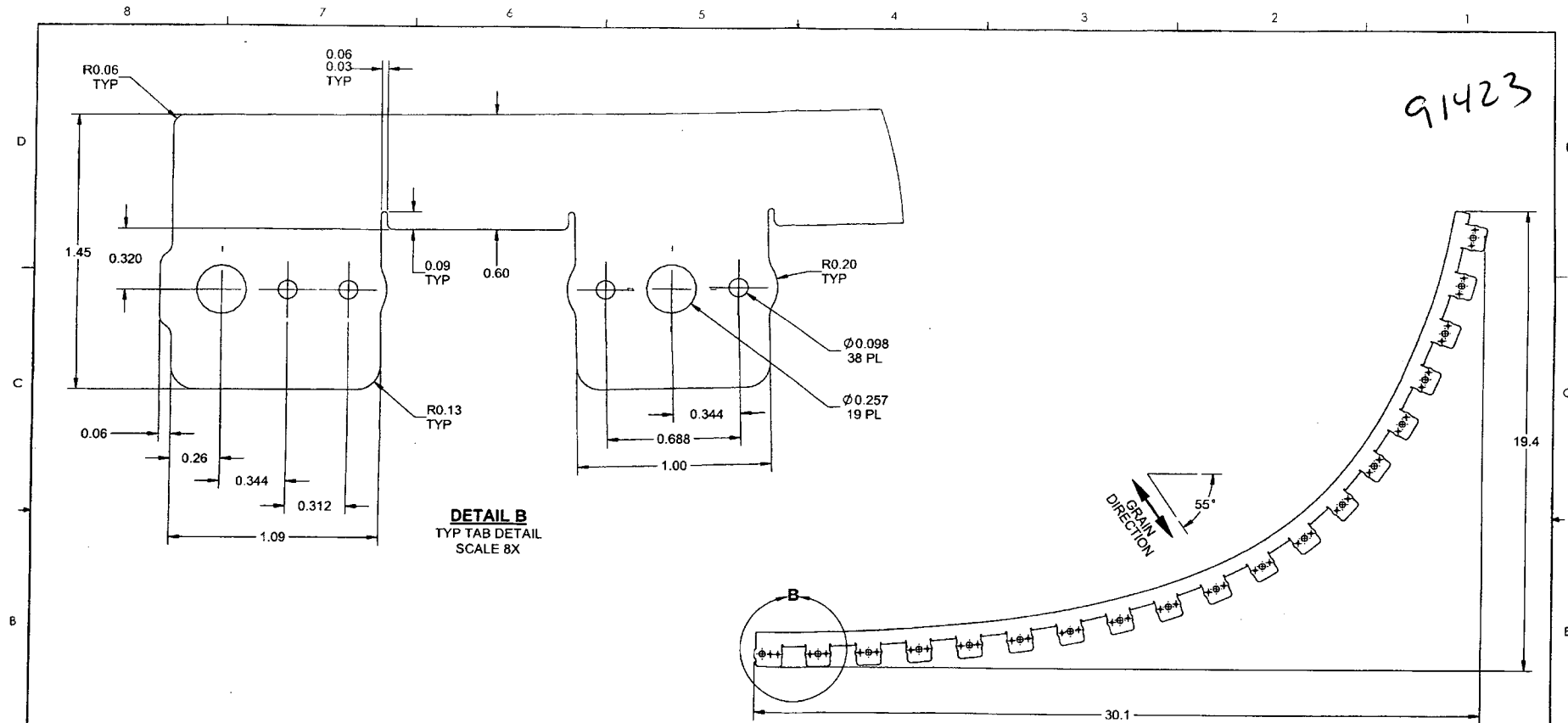
Location	Loc Qty	Loc Code
MAT021	700.06	
121099	85.97	
122256	40.89	
122737	30.1	
123097	91.1	
123135	96	
123137	356	

~~123483~~  
123483





91423



# D4541-2 BRACKET

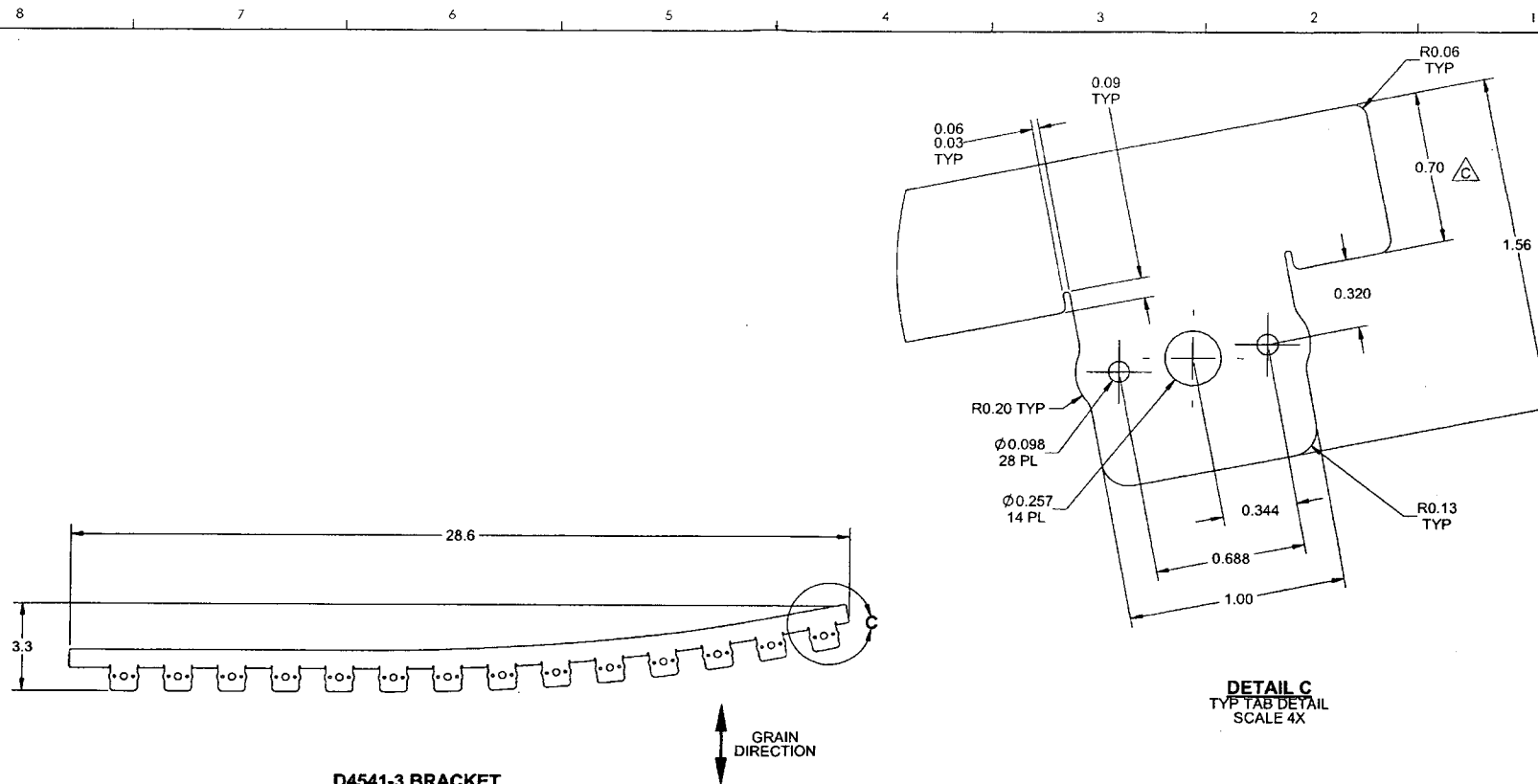
RELEASED  
2012-05-03

## NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK  
PER QQ-A-250/11 OR AMS 4025 OR ASTM B209  
REF DART SPEC. M6061T6S.032
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.12 lbs
- 8) PROFILE PER DRAWING FILE "D4541-2-REVC.DXF"

DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED			DRAWING NO. <b>D4541</b>	REV. <b>C</b>
MFG. APPR.				SHEET 2 OF 7
APPROVED			TITLE	SCALE
DE APPR.			<b>BRACKET</b>	NTS
DATE	12.02.20		COPYRIGHT © 2012 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

91423



**D4541-3 BRACKET**

**DETAIL C**  
TYP TAB DETAIL  
SCALE 4X

**RELEASED**  
2012-05-07  
AMP

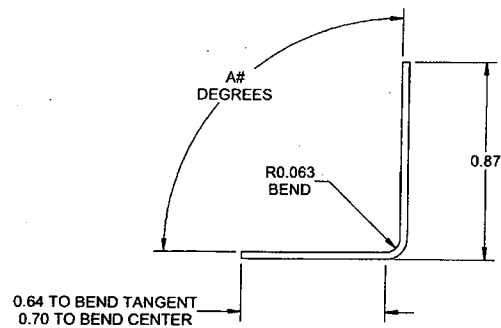
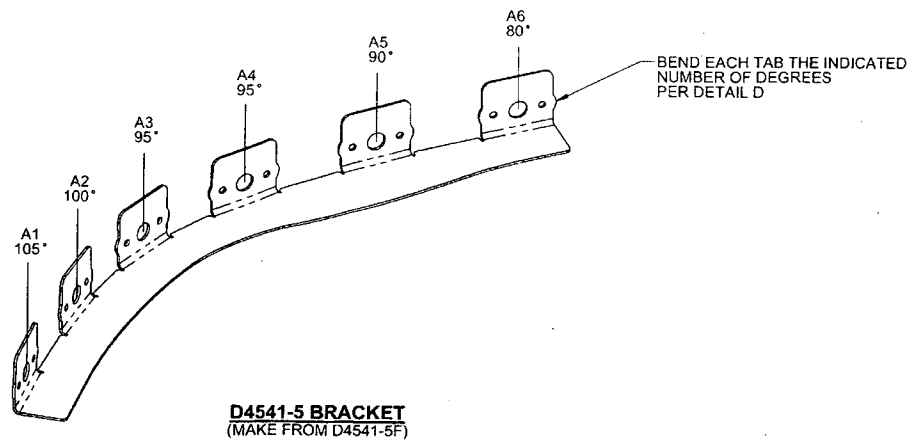
**NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK  
PER QQ-A-250/11 OR AMS 4025 OR ASTM B209  
REF DART SPEC. M6061T6S.032
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.09 lbs
- 8) PROFILE PER DRAWING FILE "D4541-3-REVC.DXF"

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. C
MFG. APPR.		D4541	SHEET 3 OF 7
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	12.02.20	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



91423



**DETAIL D**  
BEND DETAIL  
SCALE 2X

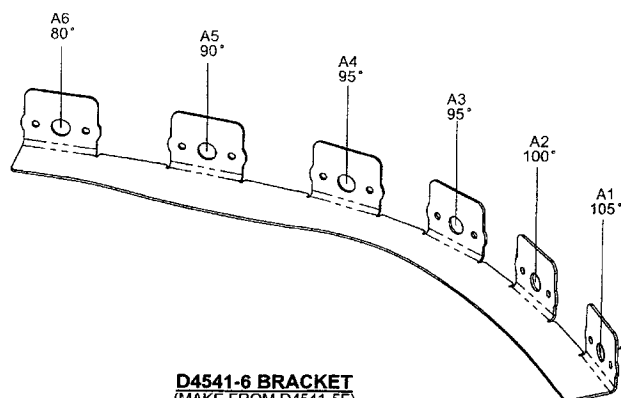
**NOTES:**

- 1) MATERIAL: MAKE FROM D4541-5F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: DART P/N & B/N PER DART QSI 044 6.1
- 7) WEIGHT: 0.04 lbs

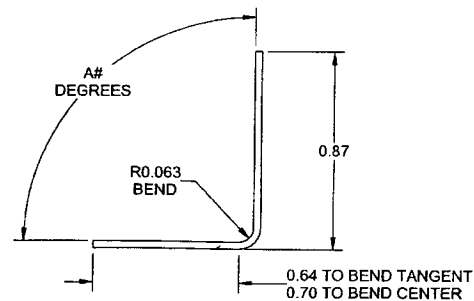
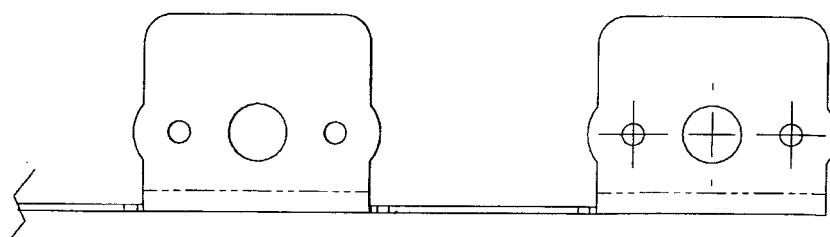
DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D4541	SHEET 4 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BRACKET	NTS
DATE	12.02.20	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

**RELEASED**  
2012-05-07

91423



**D4541-6 BRACKET**  
(MAKE FROM D4541-5F)



**DETAIL E**  
BEND DETAIL  
SCALE 2X

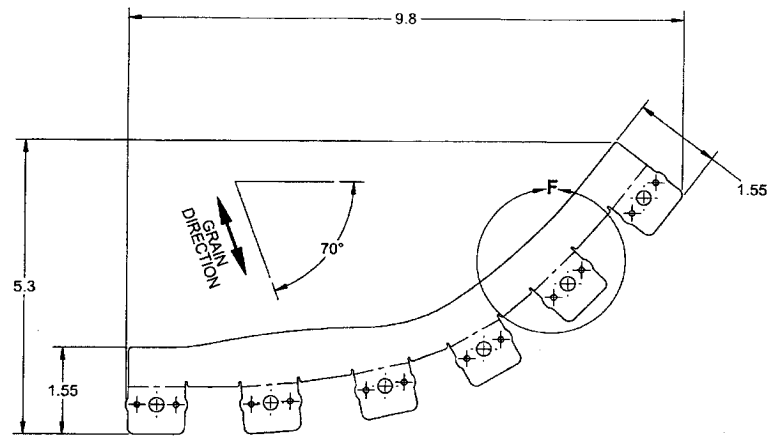
RELEASED  
2012-05-07

**NOTES:**

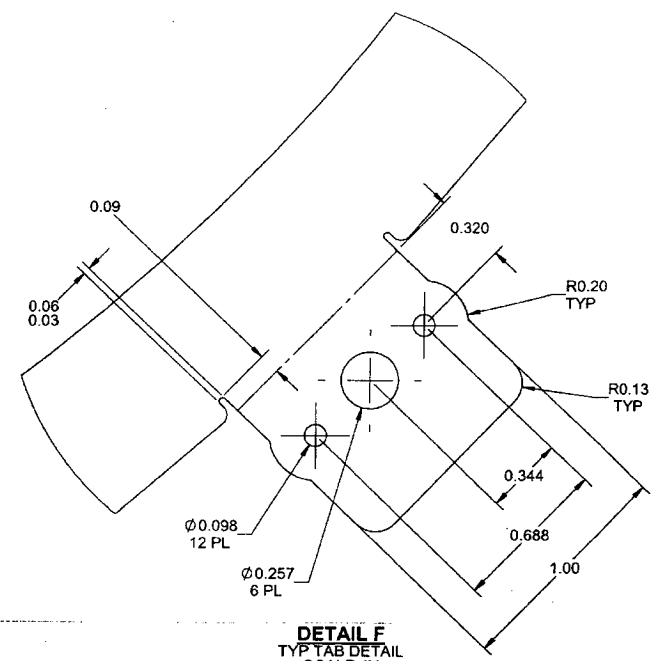
- 1) MATERIAL: MAKE FROM D4541-5F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: DART P/N & B/N PER DART QSI 044 6.1
- 7) WEIGHT: 0.04 lbs

DESIGN	g	<b>DART AEROSPACE LTD</b>	
DRAWN	g	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. C
MFG. APPR.	W	<b>D4541</b>	SHEET 5 OF 7
APPROVED	W	TITLE	SCALE
DE APPR.	W	<b>BRACKET</b>	NTS
DATE	12.02.20	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR TRANSMITTED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

91423



**D4541-5F FLAT PATTERN**



**DETAIL F**  
TYP TAB DETAIL  
SCALE 4X

RELEASED  
2012-05-07

- NOTES:**
- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK  
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC. M6061T6S.032
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 0.04 lbs
  - 8) PROFILE PER DRAWING FILE "D4541-5-REVC.DXF"

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D4541</b>	REV. C
MFG. APPR.		TITLE	SHEET 6 OF 7
APPROVED		<b>BRACKET</b>	SCALE
DE APPR.			NTS
DATE	12.04.20	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

91423

